

Item ID:

D119-646-143

Setup Start



**Revision ID:** 

Item Name:

Required Date: 3/19/10

Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

**Start Date:** 

3/11/10

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID: Customer:** 

Draw

Number

Reference:

**Approvals:** 

Sequence ID/

**Process Plan:** 

QC:

Operation

Date: Date:

Tooling:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

Draw

Rev.

Plan

Code

Accept

Qty

Start Run

Reject

Qty

Number

Stop

Stop

Reject

Stamp

**Work Center ID Description Revision Nbr Draw Nbr** D3905 В D3905-043,-11 В IIN-D119-646 В

100

Document Control

Memo

0.00

0.00

0.00

Photocopy bluefile &type labels per PPP D119-646-143

CHG 001

110

Skidtubes

Skidtubes

Memo

1- Inspect Mat'l D2500-1-190 for damage

2- Ensure squareness of ends

0.00

#### Work Order ID 56859

Page 2

March 11, 2010 10:10:47 AM

Item ID:

D119-646-143

Accept

Setup Start

**Revision ID:** 

Item Name:

3/11/10

Start Qty: 1.00 Req'd Qty: 1.00

**Cust Item ID:** 

**Customer:** 

Reference:

**Start Date:** 

**Approvals:** 

**Process Plan:** 

Date:

**Tooling:** 

Date:

Run

Start

Stop

Required Date: 3/19/10

Date: \_\_\_\_

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

120

HandFinish

Operation Description

Chemical Conversion Coat per QSI005 4.1

Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Set Up/ **Run Hours** 

0.00

Draw Number

Draw Plan Rev. Code Accept Qty

Reject Qty

Reject Insp. Number Stamp

110/3/16

Hand Finishing

Memo

0.00

130

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

150

Skidtubes Skidtubes

0.00

0.00 Memo

1- Install drill jig DT9480 drill all x-bolt spacer holes using 3/16 drill

2- Scribe batch # inside aft end of tube

	1 _	·	•_		
<b>T T</b> 7				117	56859
W	nrv		rner		70274
**			ucı	11/	20022



March 11, 2010- 10:10:51 AM

Item ID: Revision ID:	D119-646-	-143		Accept		Se	tup Sta	1 (88)		
Item Name:	Replacemen	nt Float Skidtube w/ Full I	ength Wearplates &	Wearpads					St	ор
Start Date: Required Date Reference:	3/11/10 e: 3/19/10	Start Qty: 1.00 Req'd Qty: 1.00			Cust Item I Customer:	D:				
Approvals:	Process I	Plan:	Date:	Tooling:		ate:		Ru		art
	QC:		Date:		D:	ate:			St	top
Sequence ID/		Operation Description		Set Up/	Draw	Draw	Plan	Accept	Reject	Reject

Work Center ID 155

Description

Run Hours

Number

Qty

Number Stamp

Insp.

CNC Bend 1

CNC Delta 100 Bender

Memo

0.00

0.00

1- Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Must use bending Aid DT9538, located 23.25" from Aft end.

2- Esure bending Aid DT9538 is positioned correctly, that the bender set up in on full wide and that the indexing ridge is covered with graphite grease.

165

Memo

QC5- Inspect part completeness to step on W/O

0.00

h2 5.250 & Swlv3/17

Quality Control

W	ork	Orda	er ID	568	59
VV.	OFK	Oru	עניוז	<b>300</b>	ンフ



March 11, 2010	10:10:52 AM	1										rage 4
Item ID: Revision ID: Item Name: Start Date:	D119-646-143  Replacement Float Skidtube w/ Full Length Wearplates & S/11/10 Start Qty: 1.00		ength Wearplates & Wo	Accept					Setup	Start Stop	1 18811101 0	
Required Date: Reference:		Req'd Qty: 1.00			Cust Iter Custome				_	G.		
Approvals:	Process Pla	n:	D.4.			Date:		ŀ	Run	Star		
Sequence ID/ Work Center II 180	)	Operation Description		Set Up/ Run Hours 0.00	Draw Numbe	Draw r Rev.	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Skidtubes Skidtubes	M.10 is	2- Buff out  3- Drill Aft section F-F  4- Drill Aft D3905 deta  5- Open x-b ***DO NO  **DO NO  ***DO NO  **DO NO  ***DO NO  **DO NO  ***DO NO  **DO NO  *	marks left from bending.  Float bag holes using DT9 open to finished size  wearplate and wearpad holding open to finished size  oolt spacer holes to finished TOPEN FWD SADDLE Hold out chips from inside to in place as per Dwg D390 aftex-291 January Hard of the place as per Dwg D390 aftex-291 January Hard of the place as per Dwg D390 aftex-291 January Hard of the place as per Dwg D390 aftex-291 January Hard of the place as per Dwg D390 aftex-291 January Hard of the place as per Dwg D390 aftex-291 January Hard of the place as per Dwg D390 aftex-291 January Hard of the place as per Dwg D390 aftex-291 January Hard of the place as per Dwg D390 aftex-291 January Hard of the place as per Dwg D390 aftex-291 January Hard of the place as per Dwg D390 after the place as per D390 after the pl	493 as per dwg D3905 des using DT9546 and Description of tube D3905 de	ns D-D and E-E)	to p	inistof		as par	sid	g 0396	25 to 0,56

#### Work Order ID 56859



Page 5

March 11, 2010-10:10:57 AM

Item ID:

D119-646-143

Accept



.Setup Start

Stop



**Revision ID:** 

Item Name:

Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date:

3/11/10

Start Qty: 1.00 Req'd Qty: 1.00

Date:

**Cust Item ID: Customer:** 

Required Date: 3/19/10

Reference:

Process Plan:

Date:

Tooling:

Date:

Run Start



Approvals:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID** 

190

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/

**Run Hours** 

Draw Number

Draw Plan Rev.

Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

Quality Control

Memo

Memo

200



CNC Delta 100 Bender

0.00

1- Bend Fwd end of tube using bender 1 and bend prog. D3905 Fwd.Use bending aid DT9544 ensure proper positioning

2- Cut Fwd end of tube as per dwg.

\*\*\*VERIFY MEASURMENT BEFORE CUTTING\*\*\*

-	WORK ORDER C	HANGES				
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
	STEP		STEP PROCEDURE CHANGE By			STEP PROCEDURE CHANGE By Date Qty Chief Eng /

Part No: DII9-646-143 PAR #: \_\_\_\_ Fault Category: Skill bes \_\_\_ NCR Yes No DQA: \_\_\_ Date: 1065-20

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: 10/05/20

WORK ORDER NON-CONFORMANCE (NCR)

NCR: 56	58591	VV	ORK ORI	DER NON-CONFORMANC	E (NCH)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B  Action Description  Chief Eng	Sign &	Verification Section C	Approval Chief Eng	Approva QC Inspecto
10.4,06	Zou	FRONT IS OVERBENT.  IF EIGHT IS 5.4" @ 178.5  TOTAL TENGTH. TOTAL  LENGTH IS UNDER TOL BY  0.5".  L.C. DIMEDICAL SLIPPASE / Process.	10.04.06 pi- QSI 042	Acceptable.	10-4-5	Sulvolia	10.04.06 pu QSI 042	s lul

March 11. 2010 -10:10:57 AM Item ID: D119-646-143 Accept Setup Start **Revision ID:** Stop Replacement Float Skidtube w/ Full Length Wearplates & Wearpads Item Name: **Start Date:** 3/11/10 Start Qty: 1.00 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 3/19/10 **Customer:** Reference: Run Start Process Plan: Date: **Approvals:** Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Plan Reject Set Up/ Draw Draw Accept Reject Insp. Qty **Work Center ID** Description Number Rev. Code Oty Number Stamp **Run Hours** 0.00 210 Skidtubes 0.00 Memo Skidtubes 1- Buff out marks left from bending 2- Drill Fwd cap holes using DT8215. Open Fwd and Aft cap holes to 0.208" 3- Open Fwd saddle holes to finished size as per dwg 4- Drill Fwd x-bolt hole and open to finished size. (Holes must be laid out manually) Dill wearphte hale using DT 9613 5- Drill towring hole and open to finished size. (Holes must be laid out manually)

220

QC5- Inspect part completeness to step on W/O

8- Deburr, blow out chips from inside of tube.

0.00

Memo

Quality Control

Work Order I	D 56859
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March 11, 2010 -10:11:03 AM D119-646-143

Item ID:



Setup Start

**Revision ID:** Item Name:

Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Stop

**Start Date:** 

3/11/10 Required Date: 3/19/10 Start Qty: 1.00 Req'd Qty: 1.00

**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

Date:

Start Run



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID »Operation **Description** 

Set Up/ **Run Hours**  Draw Number Draw Rev.

Plan Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

224

Skidtubes

Skidtubes

Memo

0.00

0.00

1- Countersink x-bolt holes as per dwg

2- Remove alodine prepare for welding

3- Insert x-bolt spacers

4- Weld x-bolt spacer as per dwg A/R Alum rod Batch: MILABEO

5- Grind welds flush as per dwg

6- Counter bore x-bolt holes as per dwg

7- Deburr

225

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

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XX/ handle		. II	56859
Wirk	u prater		צרמחר

March 11, 2010 - 10:11:03 AM

Item ID:

D119-646-143

Accept



Setup Start



**Revision ID:** 

Item Name:

Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Stop

Start Date:

3/11/10

Start Otv: 1.00 Rea'd Otv: 1.00

**Cust Item ID: Customer:** 

Required Date: 3/19/10 Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

Date:

Draw

Run

Start



Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

226

**Quality Control** 

Operation Description

OC10- Inspect visual per OSI004- ground welds

Set Up/ **Run Hours** 

Draw Number Rev.

Plan Code

Accept Otv

Reiect Oty

Reiect Insp. Number

Stamp

227



Hand Finishing

Memo

RE-PLODINED (PAR 09043).

D. bf 10-5-5.

240



**Powder Coating** 

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M114207

10/05/05

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F1N:12:000-

- March 11, 2010 .10:11:08 AM

Required Date: 3/19/10

Item ID:

D119-646-143

Accept



Setup Start

Stop



**Revision ID:** 

**Item Name:** 

**Start Date:** 

Replacement Float Skidtube w/ Full Length Wearplates & Wearpads 3/11/10

Start Qty: 1.00 Req'd Qty: 1.00

Date:

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

SPC (Y/N):

Date: Date:

Run

Start Stop



Sequence ID/ Work Center ID

245

Quality Control

Operation Description

QC3- Inspect Part Finish

Set Up/ Run Hours

Draw Number

Draw Rev.

Plan Qty Code

Reject Accept Qty

Reject Number

Insp. Stamp

Memo

250

HandFinish

Hand Finishing

Memo

1-Install inserts as per Dwg D3905.

0.00

=7 m/k 6/05/05

260

Quality Control

QC5- Inspect part completeness to sep on W/O

Memo

*** ' * *	$\sim$ 1	**	56859
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VV 411'K			7117777
	O L U C	1 11	20027

March 11, 2010 10:11:09 AM



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D119-646-143 Accept Item ID: Setup Start **Revision ID:** Stop Replacement Float Skidtube w/ Full Length Wearplates & Wearpads Item Name: Start Qty: 1.00 **Start Date:** 3/11/10 **Cust Item ID:** Required Date: 3/19/10 Req'd Qty: 1.00 **Customer:** Reference: Start Run **Tooling:** Process Plan: Date: Date: Approvals: Stop \_\_\_\_\_\_ Date: \_\_\_\_\_\_ SPC (Y/N): QC: Date: Reject Sequence ID/ Operation Set Up/ Draw Draw Plan Accept Reject Insp. Qty **Work Center ID** Description **Run Hours** Number Rev. Code **Qty** Number Stamp 270 0.00 0.00 HandFinish Memo Hand Finishing 1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers A/R□□Sikaflex-240/-291 Sikaflex expire date: M114189 2- install plugs assembly as per dwg. O-Ring Lub 3 -Inspect for foreign objects as per QSI 024 4 -Install Aft Cap and seal with Sikaflex. Change adhesing A/RUDSikaflex-240/-291 Sikaflex expire date: QC5- Inspect part completeness to step on W/O Memo Quality Control

#### Work Order ID 56859

Page 11

March 11, 2010 10:11:14 AM

Required Date: 3/19/10

Item ID:

D119-646-143

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

**Start Date:** 

3/11/10

Start Qty: 1.00 Req'd Qty: 1.00

**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

Date:

Code

Start Stop

QC:

Date: \_\_\_\_\_

SPC (Y/N):

Set Up/

Date:

Number

Plan Draw

Rev.

Accept Reject Qty

Run

Reject Number Stamp

Insp.

Sequence ID/ **Work Center ID** -285 780 5

Hand Finishing

Operation Description

Wing Walk as per dwg QSI005 4.4 Batch

Run Hours 13545

0.00 =7m/l Hos/05

Quality Control

QC3- Inspect Part Finish

Memo

Memo

290

Packaging

Packaging

Identify as per dwg & Stock Location:

PAP 56736

#### Work Order ID 56859

March 11. 2010 10:11:14 AM



Page 12

Item ID:

D119-646-143

3/11/10

QC:

Accept

Setup Start

Stop



**Revision ID:** 

Item Name: **Start Date:** 

Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Oty: 1.00

Required Date: 3/19/10

Req'd Qty: 1.00

Operation

Description

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date: \_\_\_\_\_

Date:

**Tooling:** 

SPC (Y/N):

Set Up/

**Run Hours** 

Date: Date:

Start



Stop

Sequence ID/

Work Center ID

300

QC

Memo

OC21- Final Inspection - Work Order Release

0.00

Draw Number

Draw Rev.

Plan Code

Reject Accept Qty Qty

Run

Reject Number

Insp. Stamp

Quality Control

0.00

10/05/19 454 MF 10-5-19

**Picklist Print** March 11, 2010 10:10:29 AM Work Order ID: 56859 Parent Item: D119-646-143 Parent Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads **Start Date: 3/11/10** Required Date: 3/19/10 Start Qty: 1.00 Required Qty: 1.00 Comments: IPP RevA: New issue DD verified by:EC Remaining Component Item ID/ Replacement Mfg/ Primary Last Route Unit of Qty on Qty Date Status Seq ID Hand Qty To Pick Issued Item Name Item ID Purch Location Location Measure Issued D2500-1-190 Each 75.0000 1.0000 Manufactured - No 110 Ext'n - I' Beam Tube 4' Warehouse Loc Qty Loc Code Location Main Warehouse 72 52319 72 Main Warehouse ST 3 3 46468 170 Each 12.0000 1.0000 D3885-3 Manufactured No Standard Web Loc Qty Loc Code Warehouse Location Main Warehouse ST 12 11 40.0000 12.0000 D3903-1 Each Manufactured Spacer Loc Code Warehouse Loc Qty Location Main Warehouse ST095 40 47476 10 51849 30

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W/O:			WC	ORK ORDER CHANG	ES			4	-		
DATE	STEP	PROC	CEDURE CHA	NGE	Ву	Da	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Ye	es No	DQA:	Date: _			
	Res	solution:	_ Dispositio	n:	_ QA: N/C	QA: N/C Closed: Date:					
NCR:		W	ORK ORD	ER NON-CONFORMA	ANCE (N	CR)					
DATE	STEP	Description of NC					Verification	Approval	Approval		
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#### **Picklist Print**

Page 2

March 11, 20:10 10:10:30 AM

Work Order ID: 56859 Parent Item:

D119-646-143

Parent Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

**Start Date: 3/11/10** 

Required Date: 3/19/10

Comments:

IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/		Primary	Last
tem Name	Item ID	Purch		Location	Loca
tem Name	Item ID	Purch	Item	Location	Lo

Seq ID Location 190

Route Unit of Measure

Qty on Hand

Remaining Qty Qty To Pick Issued Date Issued

Status

D3681-1

Manufactured

Purchased

No

Each

9.0000

8.0000 

Spacer

vv ai enouse
<b>Location</b>
Main Warehou

LG

51920 52898

Main Warehouse ST

47123

Each

599.0000 12:0000

D3683-3

Insert

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST078	599	
47805	599	

250

12x M/L 10/05/05

W/O:		1.01.01.01.01.01.01.01.01.01.01.01.01.01	WO	RK ORDER CHANG	ES			•	
DATE	STEP	PRO	OCEDURE CHAI	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	•	Date:	
						losed: Date:			
NCR:				ER NON-CONFORM		•			Araba 1
DATE	STEP	Description of NC			tion B			Approval	Approval
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#### **Picklist Print**

March 11, 2010 10:10:30 AM

Page 3

Work Order ID: 56859

D119-646-143

Manufactured

No

Parent Item Name:

Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Comments:

Parent Item:

IPP RevA: New issue DD verified by:EC

**Start Date: 3/11/10** 

Required Date: 3/19/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			250	Each	834.0000	42.0000			

Insert

Loc Code Warehouse Loc Qty Location M 114407 Main Warehouse ST282 834 110511 834

2.0000

270 Manufactured No Each 11.0000

Cap

D2855-3

Warehouse Loc Qty Loc Code Location Main Warehouse 11 fp5 11 270 1.610.000 4.0000 Each

2xm/ 10/05/05

Phenolic Washer

D3672-1

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST077	1610	
39275	19	
42329	5	
47628	86	
51674	500	
52505	1000	

HX m, L wloslos

Duit Ac	ospace	LIG							,
W/O:			WO	RK ORDER CHANG	GES			•	
DATE	STEP	PR	OCEDURE CHAP	NGE	Ву	D	ate Qty	Approval. Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	gory:	NCR: Y	es No	DQA:	Date: _	
	Resolution: Disposition:								
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)			
		Description of NC		Corrective Action Sec	tion B		Verification	Ammental	Annewal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C	Approval Chief Eng	Approval QC Inspector
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March 11, 2010 10:10:30 AM

Work Order ID: 56859

Parent Item:

**Comments:** 

D119-646-143

Parent Item Name:

Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

**Start Date: 3/11/10** Start Qty: 1.00

Required Date: 3/19/10

Required Oty: 1.00

	-			
Compo	ne	nt	Item	ID/
Item Na	ım	e		

Replacemen	t
Item ID	

Mfg/ Purch

IPP RevA: New issue DD verified by:EC

**Primary** Bin Item Location Last Location Route Seq ID

Unit of Measure

Qty on Hand

Remaining Qty Qty To Pick

Date Issued Issued

Status

D3846-1

Manufactured

Manufactured

No

270

Each

49.0000

1.0000

GASKET

<u>Warchouse</u>	L
<b>Location</b>	
Main Warehouse	
ST236B	
47806	
51827	

53735

No

Loc Qty Loc Code 49 11 6 32

Each

27.0000 1.0000 D3846-11

**GASKET** 

Warehouse Location		Loc Qty	Loc Code
Main Warehouse FP	/	16	

270

Main Warehouse ST

47807

51833

16

11 11

1xm-2 10/05/06

W/O:			WO	RK ORDER CHANG	ES				-	
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Categ	ory:	_ NCR: Y	es N	o <b>DQ</b> /	A:	Date: _	
	Res	olution:	Disposition	:	QA: N/C Closed: Date:					
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)			,	
DATE	STEP	Description of NC			ion B	Verification		Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Secti		Chief Eng	QC Inspector
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#### **Picklist Print**

March 11, 2010 10:10:31 AM

Page 5

Work Order ID: 56859

Parent Item:

Comments:

D119-646-143



Parent Item Name:

Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10

Required Date: 3/19/10

IPP RevA: New issue DD verified by:EC

Start Oty: 1.00

Required Qty: 1.00

Component	Item	ID/
Item Name		

Replacement Mfg/ Item ID

Purch

Manufactured

Bin Primary Item Location Last Location Route Seq ID Unit of Measure

Oty on Hand

Remaining Oty To Pick Issued

Qty

Date Issued

Status

D3847-1

Manufactured

No

No

270

Each

35.0000

Loc Code

8.0000

WEARPAD

Warehouse Location

Main Warehouse

ST 47808 51823

Loc Otv

35 31

Each

17.0000 1.0000 Bxm. L W/os/os

D3847-11

WEARPAD

Warehouse	Loc Qty	Loc Code
<b>Location</b>		
Main Warehouse		
FP	15	
51824	15	
Main Warehouse		
ST	2	
47809	2	

270

1x m/l 15/05/65

copace Lia										
		WORK ORDER (	CHANGES		- 1. · · · · · · · · · · · · · · · · · ·					
STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvar			
					<u> </u>					
		·								
<b>:</b>	PAR #:	Fault Category:	NCR: Yes	No <b>DQ</b>	A:	Date:				
		Disposition:	QA: N/C C	losed:						
	STEP	STEP PR :PAR #:	WORK ORDER OF STEP PROCEDURE CHANGE  PROCEDURE CHANGE  PAR #: Fault Category:	WORK ORDER CHANGES           STEP         PROCEDURE CHANGE         By	WORK ORDER CHANGES           STEP         PROCEDURE CHANGE         By         Date	WORK ORDER CHANGES           STEP         PROCEDURE CHANGE         By         Date         Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr			

NCR:			WORK ORI	DER NON-CONFORMANO	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	A	Annaugi
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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March 11, 2010 10:10:31 AM

Work Order ID: 56859

D119-646-143



Parent Item Name:

Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Comments:

Parent Item:

IPP RevA: New issue DD verified by:EC

**Start Date: 3/11/10** 

Required Date: 3/19/10

Start Qty: 1.00

Required Qty: 1.00

Component	Item	ID/
Item Name		

Replacement Mfg/ Item ID

Purch

Bin Primary Item Location Last Location

Route Seq ID

Unit of Measure

Qty on Hand

Remaining **Qty To Pick** 

Date Issued Issued Status

D3672-3

Manufactured

Purchased

No

No

270

Each

492.0000 12.0000

Phenolic Washer

Warehouse	<u>L</u> c	oc Qty	Loc Code	
Location				
Main Warehouse				
ST077		492		
51596		1		
51596 55560	,	491		
	270	Each	541.0000	46.0000

Tax m. L Woslas

**Qty** 

AN3C5A

Bolt

<u>Warehouse</u>	Loc Qty	Loc Code
Location	1111770	
Main Warehouse	M 114330	
ST351	541	
111424	8	
111707	69	
112314	1	
113121	37	
113149	126	
114056	200	
114108	100	

46x m. L 20/05/05

		<del></del>									
W/O:	0: WORK ORDER CHANGES							· · · · · · · · · · · · · · · · · · ·			
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву	By Date Qty Chief			Approval Chief Eng / Prod Mgr  Approval QC Inspector		
	-										
Part No: PAR #:		PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:				
Resolution:			Disposition		_ QA: N/C C	losed:		Date: _			
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCI	₹)					
DATE	STEP	STEP Description of NC	Corrective Action Section B			Verific	cation	Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector		
17.111.4.											

March 11, 2010 10:10:32 AM

Work Order ID: 56859

Parent Item:

**Comments:** 

D119-646-143



Parent Item Name:

Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

IPP RevA: New issue DD verified by:EC

**Start Date: 3/11/10** 

Required Date: 3/19/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Bin Primary Item Location Last Location

Route Seq ID Unit of Measure

Qty on Hand

Remaining Oty To Pick

Date Issued Issued

Status

AN960C10L

Purchased

Purchased

No

No

270

Each

388.0000

46.0000 

washer

NAS1149C0332R

Warehouse

Location

M114341 Loc Qty

Loc Code

Oty

**OFFSHORE** FG

103585

100 100

Main Warehouse ST

288 112116 128

270

112612

160 Each

473.0000 12.0000



AN960C416

washer

Warehouse Location

Main Warehouse

ST346 100993 473 473

Loc Qty

Loc Code

12 x m 1/2 s/05

rospace	e Ltd								•		
		W	ORK ORDER CHAN	GES	* 10%	***		•	,		
STEP	PRO	CEDURE CHA	NGE	Ву	By Date Qty			By Date Qty Chief B		Approval, Chief Eng / Prod Mgr	Approval QC Inspector
		WH									
Part No:         PAR #:         Fault Category:         NCR: Yes No DQA:						A:	_ Date: _				
R	esolution:	Disposition	n:	QA: N/C	Close	ed:		Date:			
	V	WORK ORD	ER NON-CONFORM	MANCE (N	CR)						
STEP	Description of NC					Verification		Approval	Approval		
	Section A	Chief Eng	Chief Eng			Secti	on C	Chief Eng	QC Inspector		
	STEP	:PAR #:	STEP PROCEDURE CHA  :PAR #:Fault Cate  Resolution:Disposition  WORK ORD  STEP Description of NC Section A Initial	WORK ORDER CHAN  STEP PROCEDURE CHANGE  :PAR #:Fault Category:  Resolution:Disposition:  WORK ORDER NON-CONFORM  STEP Description of NC	WORK ORDER CHANGES   By	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By D  :PAR #: Fault Category: NCR: Yes No Resolution: Disposition: QA: N/C Close  WORK ORDER NON-CONFORMANCE (NCR).  STEP Description of NC Section A  Initial Action Description Sign &	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By Date  :PAR #: Fault Category: NCR: Yes No DQA  Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By Date Qty  :PAR #: Fault Category: NCR: Yes No DQA:  Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr  :PAR #:Fault Category:NCR: Yes No DQA:Date:  Resolution:Disposition:QA: N/C Closed:Date:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC		

#### **Picklist Print**

March 11, 2010 10:10:33 AM

Page 8

Work Order ID: 56859

D119-646-143

Parent Item: Parent Item Name:

Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Comments:

IPP RevA: New issue DD verified by:EC

Start Date: 3/11/10

Required Date: 3/19/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Bin Primary Location Item

Last Location Route Seq ID Unit of Measure

Qty on Hand

Remaining **Qty To Pick** 

Qty Issued Date Status Issued

MS27039C4-08

Purchased

Manufactured

No

No

270

270

Each

69.0000

12.0000

**SCREW** 

Warehouse Location

Main Warehouse

ST293

17831

Loc Otv

Loc Code

69 69

Each

74.0000 16.0000 10/05/05

D3492-045

Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

51638

Main Warehouse

ST

74 74

NAS1611-005

O-Ring

Batch: M106099

16 x m-1 / 10/05/05

Dart Ae	rospace Ltd							
W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
						,		
							<del></del>	
Part No: PAF		PAR #:	Fault Category:	NCR: Ye	s No <b>DQ</b>	A:	Date: _	
		on:	Disposition:	QA: N/C	Closed:		Date:	
NCR:			WORK ORDER NON-CON	FORMANCE (NO	CR)			

	•	WORK ORD	ER NON-CONFORMANC	E (NCR)			
	Description of NC		Corrective Action Section B			Annuoval	Ammassal
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
							-
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Corrective Action Section B Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Initial Action Description Sign & Section C Chief Eng

#### **Picklist Print**

March 11, 20:10 10:10:40 AM

Page 9

Work Order ID: 56859

D119-646-143



Parent Item Name:

Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

**Start Date: 3/11/10** 

Required Date: 3/19/10

Comments:

Parent Item:

IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Bin **Primary** Item Location Last Location

Route Seq ID Unit of Measure Hand

Qty on

Remaining Qty **Qty To Pick** Issued Date Issued

Status

D3847-043

Manufactured

Manufactured

No

No

270

Each

10.0000

1.0000

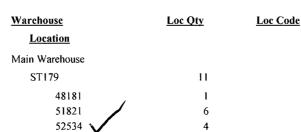
FWD WEARPLATE ASSY, STD/ FLOAT GEAR

Warehouse	Loc	Oty	Loc Code	
<b>Location</b>				
Main Warehouse				
FP		4		
52533		4		
Main Warehouse				
ST179	,	6		
48180		1		
51820		5		
	270	Each	11.0000	1.0000

1x m-2 10/05/05

D3847-045

CENTER WEARPLATE ASSY, STD/FLOAT



== h w/05/05

Dart Aerospace i	Ltd
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	•								,
W/O:			WORK ORDER CHANGES						
DATE	STEP	PR	PROCEDURE CHANGE			By Date Qty			Approval QC Inspector
									f F
		<u> </u>							
Part No: PAR #:		Fault Cate	gory:	_ NCR: Yes	No DQ	<b>\:</b>	Date:		
	Reso	olution:	Disposition	n:	_ QA: N/C CI	osed:		Date:	
NCR:			WORK ORD	R NON-CONFORM	ANCE (NCR	()			
DATE	STEP	Description of NC	C Corrective Action Section E			Veriticatio			Approval
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Approval Chief Eng	QC Inspector
				,					
	1				,				

# **Picklist Print**

March 11, 2010 10:10:40 AM

Page 10

Work Order ID: 56859

Parent Item:

D119-646-143



Parent Item Name:

Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

**Comments:** 

IPP RevA: New issue DD verified by:EC

**Start Date: 3/11/10** 

Required Date: 3/19/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Bin **Primary** Item Location Last Location Route Seq ID

Unit of Qty on Measure Hand

Remaining Qty To Pick Issued

Qty Date Issued Status

D3847-049

Manufactured

No

270

Each

6.0000

1.0000

AFT WEARPLATE ASSY, FLOAT GEAR

Warehouse Location Loc Oty

Loc Code

Main Warehouse

51822

ST179

12 m-l 10/05/05

W/O:			W	ORK ORDER CHANGE	:S			•	1 ,
				OTHIN OTHER DELINATION	.0				
DATE STEP			ROCEDURE CHANGE			Date	Qty	Approval. Chief Eng / Prod Mgr	Approval QC Inspector
						<del></del>			
Part No	):	PAR #:	Fault Category: N		NCR: Yes	NCR: Yes No DQA: Date:			
Resolution:			Disposition: Q		QA: N/C	QA: N/C Closed: Date:			
NCR:		,	WORK ORI	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section B		Verificat		on Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COLY SUBJECT TO AMENDMUNI WITHOUT NOTICE D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)

1		ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION		
2	Æ		Х			D3905-041	FLOAT SKIDTUBE ASSY WITH WEARPAD		
B		2		X		D3905-043			
12		3			Х	D3905-045			
12									
13					2		CAP		
14									
15							PHENOLIC WASHER		
16					8	D3681-1	SPACER		
17 8 8 1 D3847-1 WEARPAD  18 1 1 D3847-11 WEARPAD  19 1 D3847-043 FWD WEARPLATE ASSY  20 1 D3847-045 CENTER WEARPLATE ASSY  21 1 D3847-046 CENTER WEARPLATE ASSY  22 1 D3849-047 FWD WEARPLATE ASSY  23 1 D3849-047 FWD WEARPLATE ASSY  24 1 1 D3885-3 FLOAT WEB  25 1 1 D3905-11 FLOAT SKIDTUBE  26 1 D3905-13 FLOAT SKIDTUBE  27 12 12 12 D3903-1 SPACER  28 16 D3904-1 WASHER  29 12 12 12 D3683-3 INSERT  30 12 12 12 D3683-3 INSERT  B 1 42 42 10 ALS4-1032-130 INSERT  B 41 42 42 10 ALS4-1032-130 INSERT  B 44 4 AN3C56A BOLT  45 46 46 10 NAS1149C0332R WASHER (OR AN960C10L)  46 12 12 12 NAS1149C0463R WASHER (OR AN960C10L)  47 8 MS21043-3 NUT					1	D3846-1	GASKET		
18				1	1	D3846-11	GASKET		
19	[	17	8	8	1	D3847-1	WEARPAD		
20 1 D3847-045 CENTER WEARPLATE ASSY 21 1 D3847-049 AFT WEARPATE ASSY 22 1 1 D3849-047 FWD WEARPLATE ASSY 23 1 D3849-045 AFT WEARPLATE ASSY 24 1 1 D3885-3 FLOAT SKIDTUBE 25 1 1 D3905-11 FLOAT SKIDTUBE 26 1 D3905-13 FLOAT SKIDTUBE 27 12 12 12 D3903-1 SPACER 28 16 D3904-1 WASHER 29 12 12 12 D3663-3 INSERT 30 12 12 12 D3683-3 INSERT 41 42 42 10 ALS4-1032-130 INSERT 43 4 AN3C50A BOLT 45 46 46 10 NAS1149C0332R WASHER (OR AN960C10L) 46 12 12 12 NAS1149C0332R WASHER (OR AN960C10L) 47 8 MS21043-3 NUT		18	1	1	1	D3847-11	WEARPAD		
20	[			1		D3847-043	FWD WEARPLATE ASSY		
1				1		D3847-045			
22		21		1		D3847-049			
23	[				1	D3849-047			
24	∠B\ [	23			1	D3849-045			
25 1 1 D3905-11 FLOAT SKIDTUBE 26 D3905-13 FLOAT SKIDTUBE 27 12 12 12 D3903-1 SPACER 28 16 D3904-1 WASHER 29 12 12 12 D3672-3 WASHER 30 12 12 12 D3683-3 INSERT 31 16 D3411-3 WASHER  B 41 42 42 10 ALS4-1032-130 INSERT 42 46 46 14 AN3C5A BOLT 43 4 AN3C5A BOLT 44 4 AN3C50A BOLT 45 46 46 10 NAS1149C0332R WASHER (OR AN960C10L) 46 12 12 12 NAS1149C0463R WASHER (OR AN960C10L) 47 8 MS21043-3 NUT	[	24	1	1	1	D3885-3			
27 12 12 12 D3903-1 SPACER 28 16 D3904-1 WASHER 29 12 12 12 D3682-3 WASHER 30 12 12 12 D3683-3 INSERT 31 16 D3411-3 WASHER  B 41 42 42 10 ALS4-1032-130 INSERT B 42 46 46 14 AN3C5A BOLT 43 4 AN3C6A BOLT 44 AN3C5OA BOLT 45 46 46 10 NAS1149C0332R WASHER (OR AN960C10L) 46 12 12 12 NAS1149C0463R WASHER (OR AN960C10L) 47 8 MS21043-3 NUT	ĺ	25	1	1		D3905-11			
28	1	26			1	D3905-13	FLOAT SKIDTURE		
28	[	27	12	12	12	D3903-1	SPACER		
30   12   12   12   D3683-3   INSERT     31   16   D3411-3   WASHER     41   42   42   10   ALS4-1032-130   INSERT     42   46   46   14   AN3C5A   BOLT     43   4   AN3C5A   BOLT     44   4   AN3C5A   BOLT     45   46   46   10   INAS1149C0332R   WASHER (OR AN960C10L)     46   12   12   INAS1149C0463R   WASHER (OR AN960C10L)     47   8   MS21043-3   NUT	[	28			16	D3904-1			
B	[	29	12	12	12	D3672-3	WASHER		
H	[		12	12	12	D3683-3	INSERT		
H	∠B\[	31			16	D3411-3	WASHER		
43 4 AN3C46A BOLT  44 4 AN3C50A BOLT  45 46 46 10 NAS1149C0332R WASHER (OR AN960C10L)  46 12 12 12 NAS1149C0463R WASHER (OR AN960C416)  47 8 MS21043-3 NUT			-						
43 4 AN3C46A BOLT  44 4 AN3C50A BOLT  45 46 46 10 NAS1149C0332R WASHER (OR AN960C10L)  46 12 12 12 NAS1149C0463R WASHER (OR AN960C416)  47 8 MS21043-3 NUT	(뭣)	41	42	42	10	ALS4-1032-130	INSERT		
43 4 AN3C46A BOLT  44 4 AN3C50A BOLT  45 46 46 10 NAS1149C0332R WASHER (OR AN960C10L)  46 12 12 12 NAS1149C0463R WASHER (OR AN960C416)  47 8 MS21043-3 NUT	/B\	42	46	46	14	AN3C5A	BOLT		
45 46 46 10 NAS1149C0332R WASHER (OR AN960C10L) 46 12 12 12 NAS1149C0463R WASHER (OR AN960C416) 47 8 MS21043-3 NUT	- 1	43			4	AN3C46A	BOLT		
46 12 12 12 NAS1149C0463R WASHER (OR AN960C416) 47 8 MS21043-3 NUT		44			4	AN3C50A	BOLT		
46 12 12 12 NAS1149C0463R WASHER (OR AN960C416) 47 8 MS21043-3 NUT		45	46	46	10	NAS1149C0332R	WASHER (OR AN960C10L)		
47 8 MS21043-3 NUT		46	12	12	12	NAS1149C0463R	WASHER (OR AN960C416)		
		47			8	MS21043-3			
		48	12	12	12	MS27039C4-08			

D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR) D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-3 FLOAT WEB POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
3) TOLERANGES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: D3905-041 = 40.7 lbs
D3905-043 = 47.0 lbs
D3905-045 = 47.3 lbs
8) WELD PER DART QSI 004

DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8:5 INCHES
ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT
PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT

PORTION OF THE TUBE.

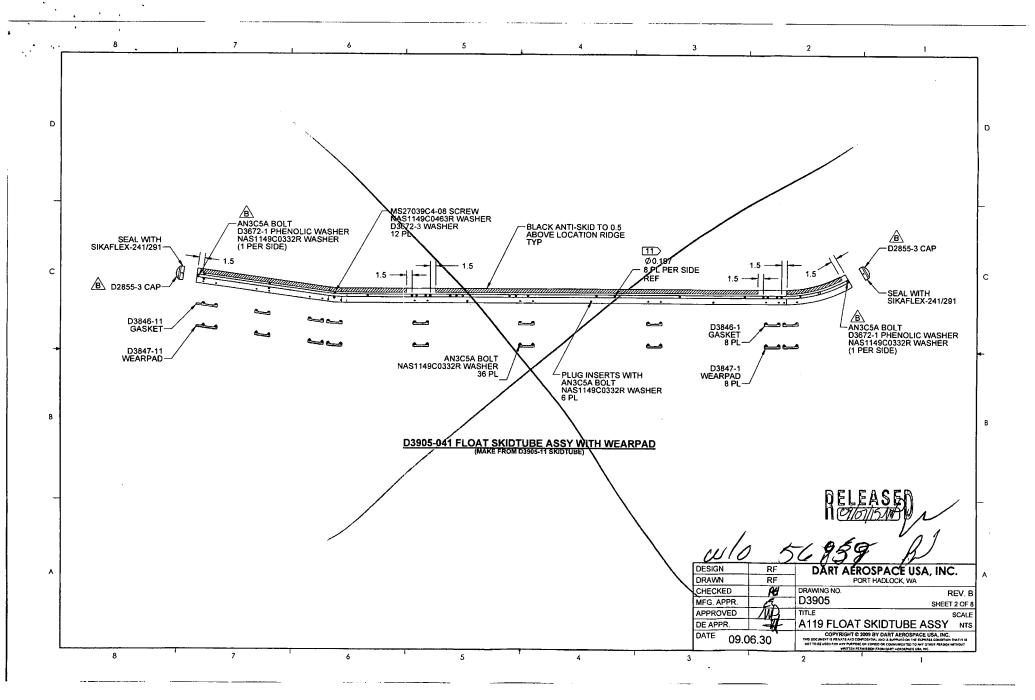
10) INSERT D388-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP

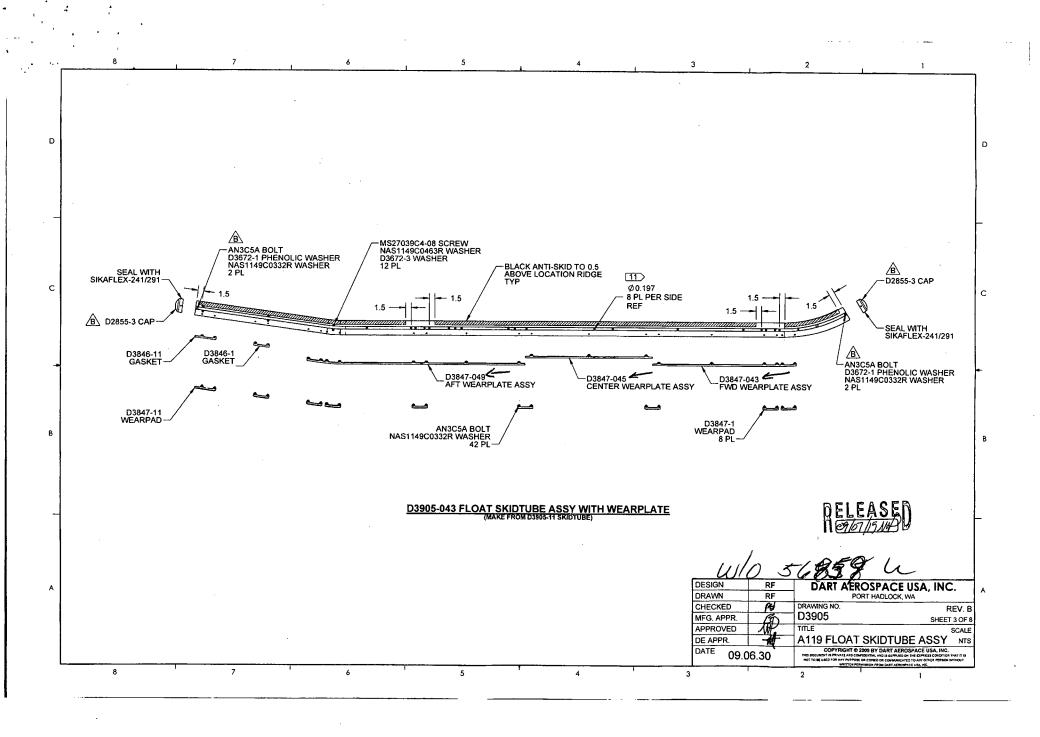
11) INSERT D3492-045 PLUG ASSY INTO Ø0.197 HOLES (BOTH SIDES OF TUBE)

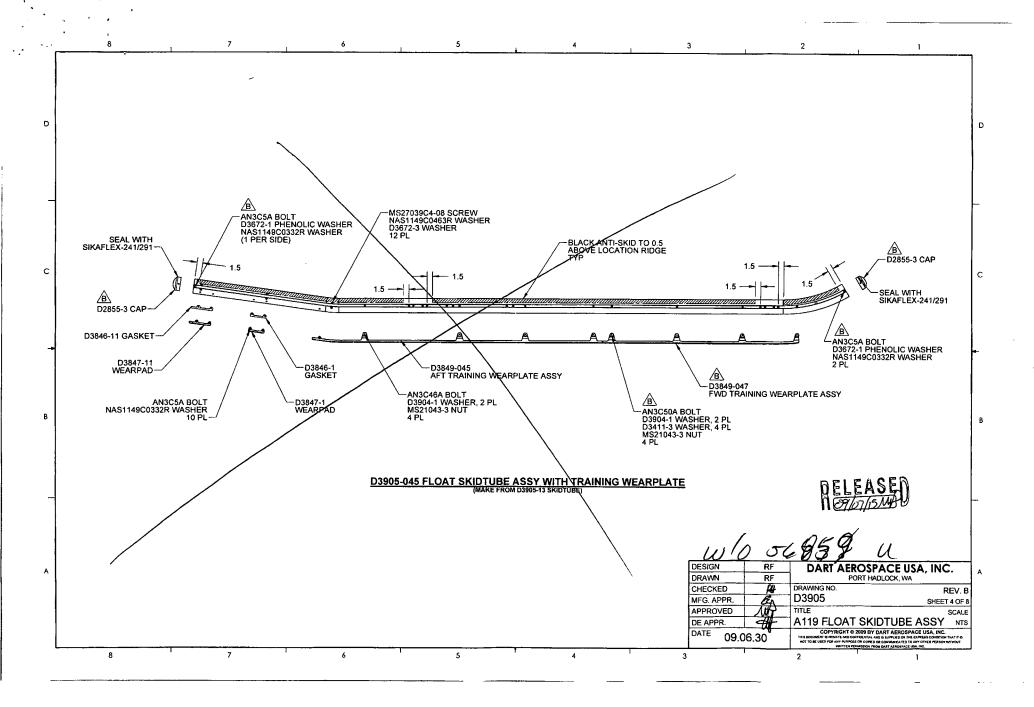
12) USE DART DRILL TEMPLATE D78932 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARPLATE INSERTS. INSTALL AELS-1032-130 INTO D3905-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/-291.

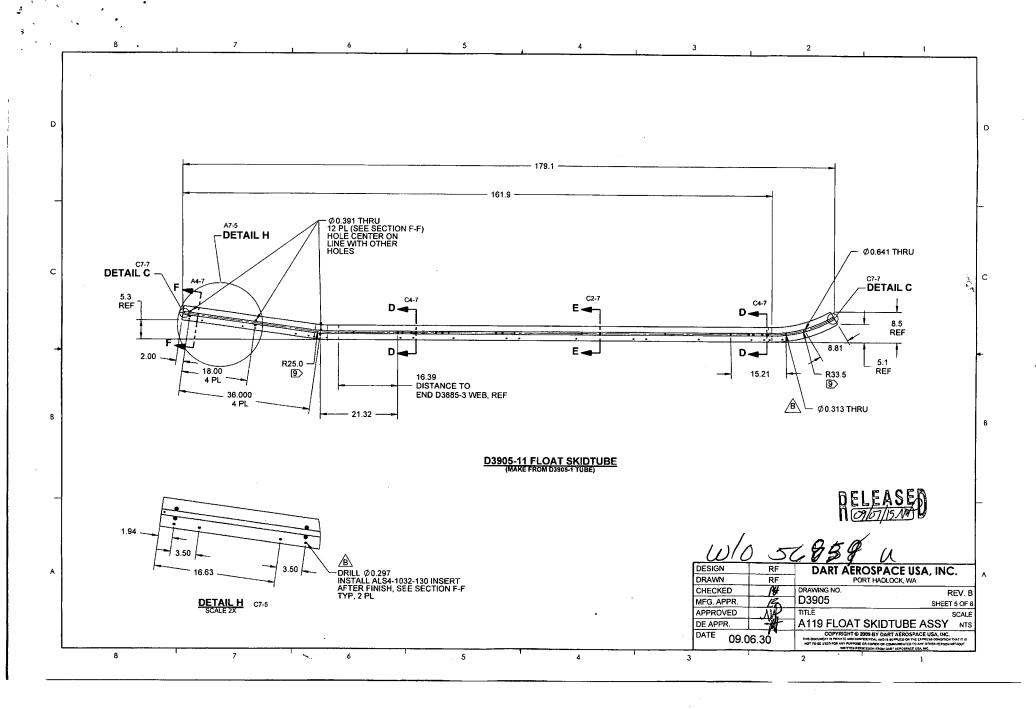
DELEASED NO967/5MA	į
11 09/07/15/WAY	

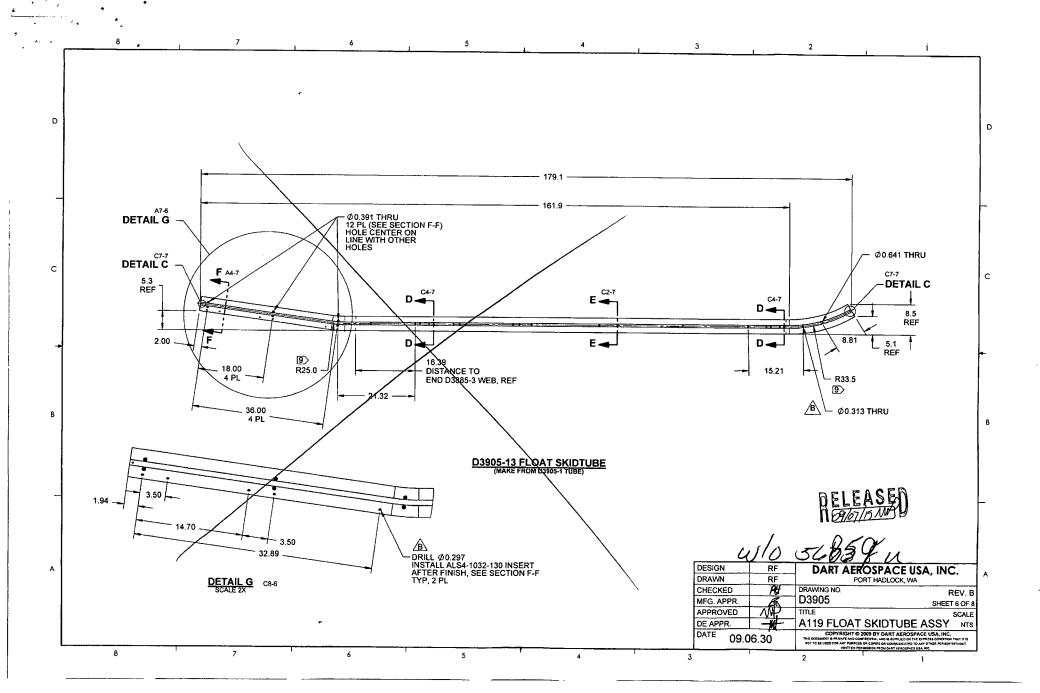
	1 55,000					
В	REVISED PART LIST. ALSA-1032-130 WAS AEL S-1032-130 (ZN A5-5 A5-6 C5-7, C3-7, A5-7): ADD D18332 (ZN A6-1): D2855-3 WAS D2375 (ZN C6-2, C1-2, C8-3, C1-3, C3-4, C1-4): AN3CSA WAS AN3CAS (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4): D3849-047 WAS D3849-041 (ZN B3-4); ADD D3841-3 (ZN B3-4); ADD AN3CSA (ZN B3-4); ADD D3841-3 (ZN B3-4); ADD AN3CSA (ZN B3-4); ADD D3841-3 (ZN B					
Α	NEWIS			RF	09.03.30	
REV.	i		DESCRIPTION	BY	DATE	
DESIGN		RF DART AEROSPACE		USA. INC.		
DRAWN		RF	PORT HADLOCK,			
CHECKED		PA	DRAWING NO.		REV. B	
MFG. APPR.		Ba	D3905		SHEET 1 OF 8	
APPROVED		7WH	TITLE		SCALE	
DE APPR.			A119 FLOAT SKIDTUE	BE AS	SSY NTS	
DATE	09.0	6.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROVINCE AND CONTROL THAN IT IS A THOUGHT ON THE METHOD THAN THE SECOND THOM THAN IT IS A THOUGHT ON A METHOD ON COMMINICATION TO ANY OTHER TRADE WITHOUT			

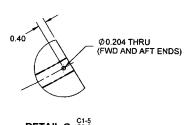




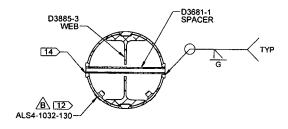








D3885-3 WEB -D3903-1 SPACER 13 <u>₿</u> 12> ALS4-1032-130 INSERT-



(FOR 12 x Ø 0.375 HOLES PER SKIDTUBE)

SECTION E-E C4-5
SCALE 4X (FOR 8 x Ø 0.313 HOLES BER SKIDTUBE)

DRILL Ø0.391 INSTALL D3683-3 INSERT B 12 ALS4-1032-130 REF

NOTES:

13) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR \$\phi\_0.375\$ HOLES ONLY:

1) CHAMFER HOLES \$\phi\_0.475 \times 45^\*\$ (BOTH SIDES)

1i) INSERT D9903-1 SPACER

1ii) WELD INTO PLACE AND GRIND FLUSH

1iv) C'BORE TO 0.313 x 0.75 DEEP

1y) DEBURR HOLES

vi) CHAMFER HOLES  $\phi$ 0.354 x 45° OR 0.050 DEEP x 45° (BOTH SIDES)

vii) INSERT D3681-1 SPACER viii) WELD INTO PLACE AND GRIND FLUSH ix) DEBURR HOLES

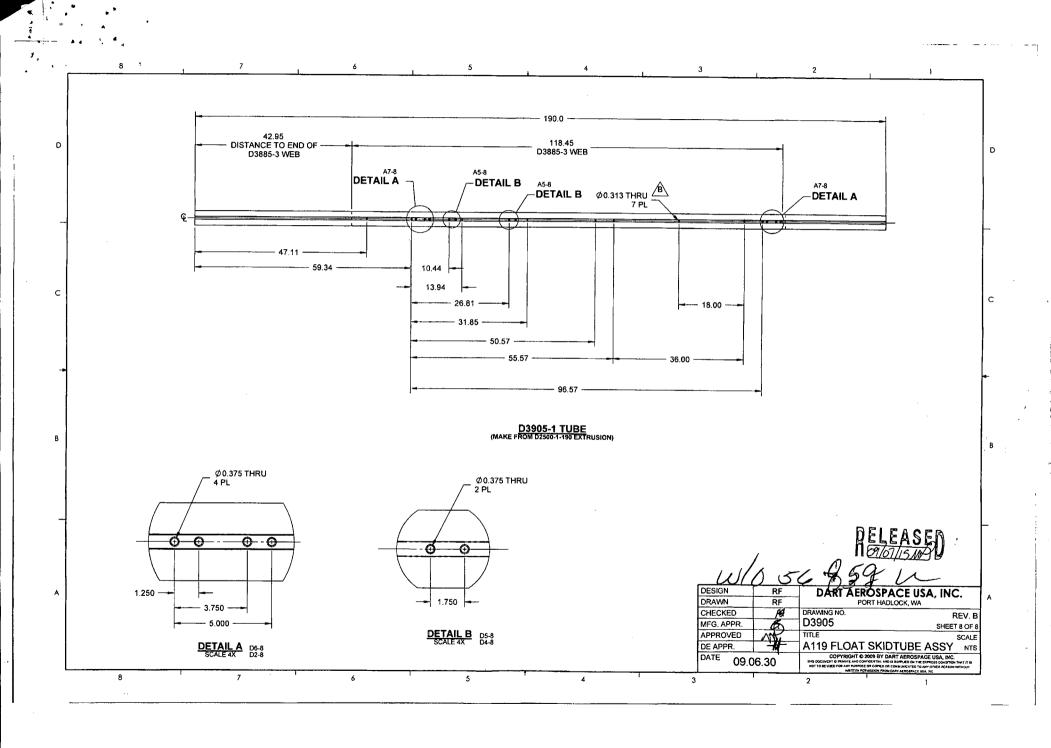
SCALE 4X C7-6

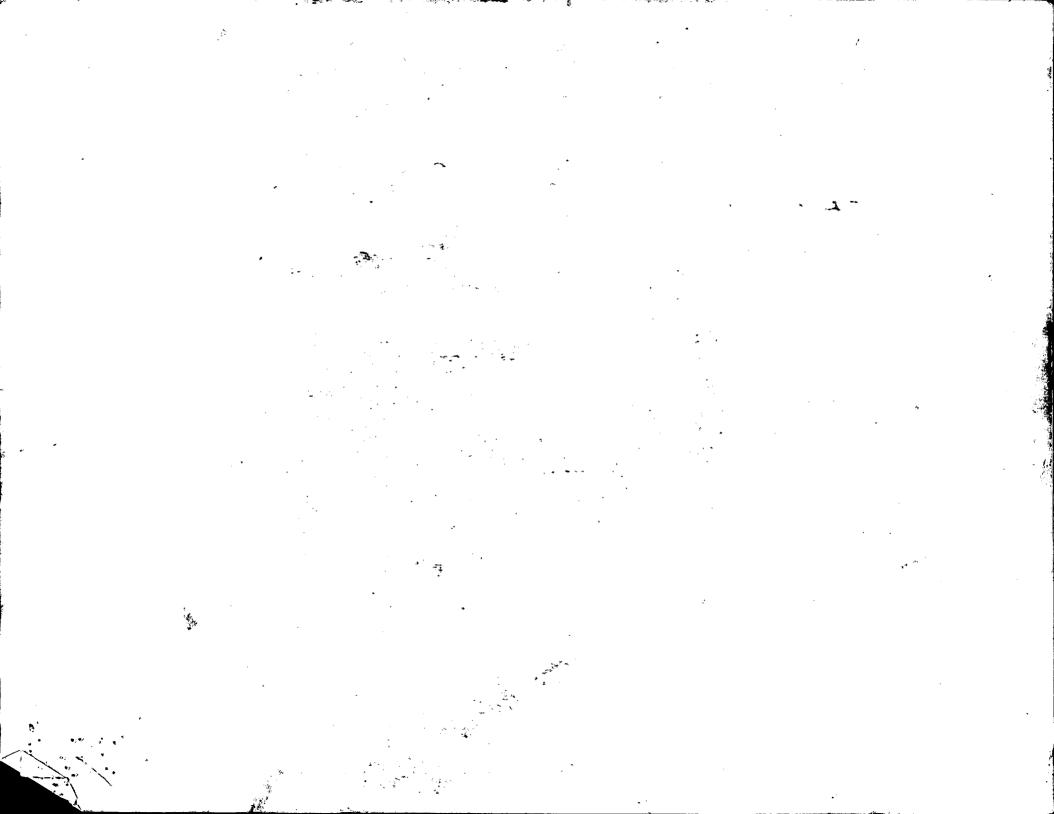
DART AEROSPACE USA, INC. DESIGN DRAWN RF PORT HADLOCK, WA DRAWING NO. CHECKED REV. B D3905 MFG. APPR. SHEET 7 OF 8 APPROVED TITLE A119 FLOAT SKIDTUBE ASSY NTS DE APPR. COPYRIGHT © 2009 BY DART AEROSPACE U.S.A. INC.
MENT IN PRIVATE AND COMPRENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITIONS
E USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO MAY OTHER PERSON DATE 09.06.30

С

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NO. an

# AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Barcha Elliott
Job number: 52996
Part number: Dig 646.243
Description: 119 skid tube
Welding Process: Tig[ Mig[ ]
Base materiel: Aluguinium
Current: AC[V] DC[]

# TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[/] fail[] pass[/] fail[]
<u>UNACCEPTABLE</u>	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier (A.) yml; Welder Dan laifellicht	Date of Test Coupon 09.11.16
f	

The above named individual is qualified in accordance with AWS D17.1.2001 to weld